



Dart Aerospace Ltd.
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D4956-15
Job Sheet 200938



Part No: D4956-15

Job Qty: 8 pcs

Part Name: Wearplate Fwd



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/19/19

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 10/10/19

Description:

Type: Stock *Super Brass*

Note: DWG REV A SHEETS 2,8 IPP REV:A 14.04.22 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	8 pcs	10/10/19	10/10/19	0.17	1.56	Waterjet - Flow	<i>9/25/19</i>	<i>JRB</i>
120	QC 8	8 pcs	10/10/19	10/10/19	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
							QC 8 - 57		
							QC 8 - 76		
130	Small Fab - Brake NC - B4B	8 pcs	10/10/19	10/10/19	0.25	0.33	Small Fab - Brake - 1 - B4B		
							Small Fab - Brake - 2 - B4B		

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Container No: S218063

Part: D4956-15

Job No: 200938

Serial No/Batch: S218063

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 09/28/19

DAS
SEP 30 2019
9-89

9/19/2019

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

				Small Fab - Brake - 3 - B4B	OCT 03 2019
140 QC 5	8 pcs	10/10/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	DAS 61
				QC 5 - 81	9-89
150 Handfinish - 4-1-Assembly-B4B	8 pcs	10/10/19	0.00 0.33	Handfinish - 4 - 1 - B4B	
				Handfinish - 4 - 10 - B4B	
				Handfinish - 4 - 11 - B4B	
				Handfinish - 4 - 12 - B4B	
				Handfinish - 4 - 13 - B4B	
				Handfinish - 4 - 14 - B4B	
				Handfinish - 4 - 15 - B4B	
				Handfinish - 4 - 2 - B4B	
				Handfinish - 4 - 3 - B4B	
				Handfinish - 4 - 4 - B4B	
				Handfinish - 4 - 5 - B4B	
				Handfinish - 4 - 6 - B4B	Rd 19-10-4
				Handfinish - 4 - 7 - B4B	
				Handfinish - 4 - 8 - B4B	
				Handfinish - 4 - 9 - B4B	
160 QC 3	8 pcs	10/10/19	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	DAS
				QC 3 - 40	OCT 07 2019 40
				QC 3 - 19	9-89
				QC 3 - 43	
				QC 3 - 24	
				QC 3 - 61	
				QC 3 - 81	

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170 Packaging 3-1 - Stock - B4B	8 pcs	10/10/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	FP-002 ML 14-10-07
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
180 QC 21 - SA	8 pcs	10/10/19	0.00 0.00	QC 21 - SA - 21	DAS 21 9-29 OCT 07 2019
				QC 21 - SA - 70	
				QC 21 - SA - 53	

Part Op 100 - 1-Cut as per Dwg Dwg Rev: A Prog Rev: A 2-Deburr if necessary
 Descriptions: 120 - (QC8- Inspect parts - second check)
 130 - FORM JOGGLE AS DWG
 140 - (QC5- Inspect part completeness to step on W/O)
 150 - 1- After finish, coat entire top (concave) surface as per note 2 dwg D4956. TEXTURED COATING
 B#: 5217452
 160 - (QC3- Inspect Part Finish)
 170 - (Identify as per dwg & Stock Location: _____)
 180 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S20GA	304/316 .040 Sheet	7.6000 sf (.95 ea)	100-Waterjet - Flow - 1	5200296

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M304S20GA	8	124	0

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Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Wearshoe	0.188Inches + 0.005 - 0.001	0.193 0.187	Diameter	
2	Wearshoe	0.300Inches ± 0.010	0.310 0.290		
3	Wearshoe	0.300Inches ± 0.010	0.310 0.290		
4	Wearshoe	2.000Inches ± 0.010	2.010 1.990		
5	Wearshoe	5.000Inches ± 0.030	5.030 4.970		
6	Wearshoe	7.650Inches ± 0.010	7.660 7.640		
7	Wearshoe	41.150Inches ± 0.010	41.160 41.140		
8	Wearshoe	13.000Inches ± 0.030	13.030 12.970		
9	Wearshoe	16.400Inches ± 0.010	16.410 16.390		
10	Wearshoe	21.000Inches ± 0.030	21.030 20.970		
11	Wearshoe	21.650Inches ± 0.010	21.660 21.640		
12	Wearshoe	26.900Inches ± 0.010	26.910 26.890		
13	Wearshoe	29.000Inches ± 0.030	29.030 28.970		
14	Wearshoe	32.150Inches ± 0.010	32.160 32.140		
15	Wearshoe	35.650Inches ± 0.010	35.660 35.640		
16	Wearshoe	37.650Inches ± 0.010	37.660 37.640		
17	Wearshoe	41.150Inches ± 0.010	41.160 41.140		
18	Wearshoe	41.530Inches ± 0.030	41.560 41.500		

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NCR No.

Job: _____ Part No. _____						DISPOSITION Rework Scrap Use-as-is								DEPARTMENT/PROCESS Cross tube Small Fab Finishing Skid-tube Machining Large Fab Eng. (Non-AW) Prod. Eng. Coord. Rec/Store/Packaging Engineering Water Jet Supplier Quality															
Date : _____						Sequence #: _____						QTY Affected : _____						MRB (QS1042)											
Description Work Order Deviation						Disposition												Completed By											
																		Lead hand / Supervisor											
																		QC / QA Coordinator											
Root Cause						FAULT CATEGORY																							
Operator Manufacturing Process Equip/Tooling Handling/Preservation Material Product Improvement Process Improvement Human Factors						Pressure/Forced Bending Crushing Cracks Crimp/Kink/Ripple/Wave/Twist Marks/Chatter Mislabeled Other/Details:						Contamination Misaligned/off center BOM/Route Broken/Damage/Defect Incomplete/Unclear Instructions Drill Holes Fit/Function						Power Loss/Surge Folio/Program Grain Direction Weld Wrong Stock Pulled Out of Sequence Off-set/Set-up						Positioned Wrong Outside Tolerance Drawing Finish Part Lost/Missing Misread					